

Date: Thursday, 6/21/2007 2:34:45 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 33083  
 Estimate Number : 10327  
 P.O. Number : *N/A*  
 This Issue : 6/21/2007 S.O. No. : *N/A*  
 Prsht Rev. : NC  
 First Issue : *N/A* Type : MACHINED PARTS  
 Previous Run : 32583  
 Drawing Name : BLADE  
 Part Number : D2741  
 Drawing Number : D2741 REV C  
 Project Number : N/A  
 Drawing Revision : C  
 Material : *N/A*  
 Due Date : 7/15/2007 Qty: 30 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : Est Rev: D 00.11.15 Removed P/O turning - in house  
 processEC  
 Est Rev: E 06-03-20 As Per Rev C  
 JLM  
 Est Rev: F 06.04.20 Added grinding after heat treating E  
 C

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M4130NB0500X03000 4130 Bar 0.5 x 3.0"



Comment: Qty.: 1.2118 f(s)/Unit Total: 36.3542 f(s)

4130 BAR 0.5 x 3.0"

Material: 4130 steel bar 0.50" x 3.00"

Batch: *M104 884x12*

*J.P. / J.F. 07/09/24*

*(30)*

2.0 BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks 13.850" long +0.063" -0.000"

*J.P. 07/09/24*

*(30)*

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio FA108

*J.L. 07/09/26*

*(30)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE

Job Number: 33083

Part Number: D2741

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

51 07/09/26

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

52 07-09-26

(30)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

SAD 07-09-27

(30)

2-Bend per Dwg D2741

53 07/09/27

(30)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

54 07/09/28

(30)

8.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting PURCHASING

Issue P/O:

4706

07/10/28

Harden material as per Dwg D2741

Min. Ultimate Tensile Strength = 152 ksi (30-40 HRC)

Min. Yield Tensile Strength = 141 ksi

Test report or Certification required

(30)

(30)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure Test report or Certification attached

55 7/10/22 (30)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

56 07-10-24

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Grind off carbon deposits

57 07/10/25 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 01/01/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

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Drawing Name: BLADE

Job Number: 33083

Part Number: D2741

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

POWDER COATING

POWDER COATING



M105068



(30X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

m-h

07/10/25

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HA



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

04-10-25

X30

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST466  
B-33083

(30X) AS

W

15.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

07/10/26

Job Completion



U 07-10-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries











**VAC AERO**  
INTERNATIONAL INC.

# PACKING SLIP

OAK 91545-1



HEAD OFFICE  
1371 SPERS ROAD, OAKVILLE, ONTARIO  
CANADA L6L 2X5  
TEL: (905) 827-4171 FAX: (905) 827-7489



QUEBEC DIVISION  
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC  
CANADA H4S 1C5  
TEL: (514) 334-4240 FAX: (514) 334-6269

GST No.: R105468102

10/17/2007

MM/DD/YYYY

PAGE: 1

110AR01

BILL TO: DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
10/17/2007	FED EX 15179324-0	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
214742		COD

LN	PART NO	DESCRIPTION	UOM	QTY ORDERED	QTY SHIPPED	B/O QTY
01	D2741	B33083  Process Specifications: Procedure: 4161 HARDENED PER DWG. D2741 TO 152 KSI MINIMUM 100% HARDNESS TESTED PER ASTM E-18, HRC: 34-40 MATERIAL: 4130	EA	30	30	0
02	MC	MINIMUM CHARGE 105 LBS @ \$2.26/LB		1	1	0

No claims for shortage in weight or count will be entertained, unless presented within 5 working days after receipt of materials by customer.



VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT  
TURBINE COMPONENT OVERHAUL - PLASMA AND OTHER COATINGS



HEAT  
TREATING



## RELEASE NOTE

GST No. : R105468102

OAK 91545-1

HEAD OFFICE  
1371 SPEERS ROAD, OAKVILLE, ONTARIO  
CANADA L6L 2X5  
TEL: (905) 827-4171 FAX: (905) 827-7489

2009 WYECROFT ROAD, UNIT B  
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1DAR01

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DATE SHIPPED	SHIP VIA	F.O.B.
10/17/2007	FED EX 15179324-0	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
214742		COD

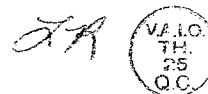
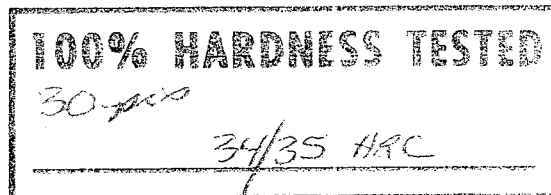
PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
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D2741

B33083

EA 30 30

Process Specifications: Procedure: 4161  
HARDENED PER DWG. D2741 TO 152 HSI MINIMUM  
100% HARDNESS TESTED PER ASTM E-18, HRC: 34-40  
MATERIAL: 4130



hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant hereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

*Diana Robinson*  
Authorized Q.C. Inspector



VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT  
THERMAL COMPONENT OVERHAUL · PLASMA AND OTHER COATINGS



HEAT  
TREATING